

19-7574



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5639-1

Job Sheet 197944



DAS
21
9-89

Part No: D5639-1

Job Qty: 5 pcs

Part Name: Saddle, Inboard, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/18/19

Job Tracking No:

Due Date: 8/2/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D5639 REV.A IPP REV.A NEW ISSUE 19/02/06 JFS VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Machining - Issue SN	6 pcs	8/2/19		0.00	0.00	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL 19/08/27
							HAAS - 4		
110	HAAS 4 Axis - B4B	6 pcs	8/2/19		3.00	6.67	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		SBL 19/08/28
							HAAS - 4 - B4B		
120	QC 2	6 pcs	8/2/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



Container No: S209027



Part: D5639-1

Job No: 197944

Serial No/Batch: S209027

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/27/19

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130 QC 8	6 pcs	8/2/19	0.00 0.00	QC 2 - 57	SBL 19/08/28
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
140 Handfinish - 1-1 Chemical-B4B	6 pcs	8/2/19	0.00 0.75	QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	marl 19/08/30
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	★ AUG 30 2019
				Handfinish - 1 - 4 - B4B	
150 QC 7	6	8/2/19	0.00 0.00	Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				QC 7 - 10	

	pcs				QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	SEP 10 2019
					QC 7 - 40	DAS 40 9-89
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
152 Spray Paint - 2 - B4B	6 pcs	8/2/19	0.00 3.00		Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	RD 19-9-10
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
154 QC 14	6 pcs	8/2/19	0.00 0.00		QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	SEP 12 2019
					QC 14 - 19	DAS 40 9-89
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
160 Packaging 3-1 - Stock - B4B	6 pcs	8/2/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	

				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	6 pcs	8/2/19	0.00 0.00	QC 21 - SA - 21	DAG
				QC 21 - SA - 70	21
				QC 21 - SA - 53	8-08
Part Op 110 - 1-Machine per folio FC512 DWG REV: 4 FOLIO REV: 44 2- Deburr and break all sharp edges Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (QC7-Inspect Chemical Conversion Coat) 152 - PRIME PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER) BATCH: 5200249 PAINT GLOSS BLACK PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT) BATCH: 5150631 154 - (QC14- Inspect Spray Paint) 160 - (Identify as per dwg & Stock Location:) 170 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6101-001	Saddle Billet	6 pcs (1 ea)	100-Machining - Issue SN	3184 644	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Machining - Issue SN	D6101-001	6	33	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order: 197944
Description: SADDLE INBOARD		Part Number: D5639-1
Inspection Dwg: D5639 Rev: A DSK: ☒ Rev: ☒		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	110	130		118	119	119	117	117
B	R 0.35	0.40		R 0.375	R 0.375	0.375	0.375	0.375
C	110	130		120	119	130	125	128
D	2.256	2.63		2.58	2.57	2.57	2.57	2.57
E	1.870	1.880		1.875	1.875	1.875	1.875	1.875
F	1.670	1.880		1.675	1.675	1.675	1.675	1.675
G	0.35	0.45		0.38	0.39	0.40	0.40	0.39
H	1.395	1.405		1.400	1.400	1.400	1.400	1.400
I	1.395	1.405		1.398	1.400	1.400	1.400	1.400
J	1.943	1.953		1.950	1.944	1.950	1.950	1.950
K	2.328	2.338		2.330	2.333	2.333	2.333	2.333
L	2.41	2.61		2.54	2.50	2.50	2.50	2.49
M	1.585	1.585		1.575	1.575	1.575	1.575	1.575
N	0.0 x 45°	0.8 x 45°		0.50	0.51	0.50	0.50	0.50
O	213	233		218	220	220	221	222
P	113	133		118	120	120	121	122
Q	R 1.16	R 2.2		1.187	R 1.187	1.187	1.187	1.187
R	110	130		119	120	121	120	119
S	0.675	0.95		0.690	0.690	0.690	0.690	0.690
T	1.346	1.366		1.354	1.355	1.355	1.355	1.355
U	1.125	1.145		1.135	1.135	1.135	1.135	1.135
V	5.990	6.010		5.999	6.000	6.000	6.000	6.000
W	1.07	1.13		1.108	1.110	1.110	1.107	1.107
X	490	510		499	500	499	500	500
Y	490	510		497	498	498	497	498
Z	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AA	2.495	2.505		2.500	2.500	2.500	2.500	2.500
AB	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AC	0.312	0.319		0.313	0.313	0.313	0.313	0.313
AD	R 2.2	R 2.8		R 2.50	2.50	2.50	2.50	2.50
AE	110	130		121	119	119	119	118
AF	115	135		125	125	125	125	125
AG	510	515		512	512	512	512	512
AH	235	240		237	237	238	237	237

Accept/Reject

Measured by: SBL	Date: 19/08/27
Audited by: [Signature]	Date: 19/08/20
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	
C	12.07.31	Prototype revised to preliminary	KJ	

DART AEROSPACE LTD		Work Order: 197944
Description: SADDLE INBOARD		Part Number: DT635-1
Inspection Dwg: D5639 Rev: A DSK: ☒ Rev: ☒		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A								
B								
C								
D								
E								
F								
G								
H								
I								
J								
K								
L								
M								
N								
O								
P								
Q								
R								
S								
T								
U								
V								
W								
X								
Y								
Z								
AA								
AB								
AC								
AD								
AE								
AF								
AG								
AH								
Accept/Reject								

Measured by: SBL	Date: 19/08/27
Audited by: [Signature]	Date: 19/08/30
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	
C	12.07.31	Prototype revised to preliminary	KJ	

Entered: 7R Date: Oct 25/19



NCR No. 19-7574

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>197944</u> Part No. <u>05639-1</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: <u>19/08/28</u>		Sequence #: <u>110</u>		QTY Affected: <u>2 (one)</u>		MRB (QSI042) <u>INSP 12 of 19/08/28</u>	
Description Work Order Deviation <u>machined belt and mark the piece.</u>				Disposition <u>Scrap and destroy</u> <u>Serial #: 5184644</u>			
Completed By: DAS 57 9-89 <u>19/08/28</u>				Lead hand / Supervisor <u>conf</u> <u>19/08/28</u>			
QC / QA Coordinator DAS 68 9-89 AUG 30 2019							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☒ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☒ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details:					